

Work Order ID 54303

December 7, 2009 3:08:15 PM



Page 1

Item ID: D3766-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Rail

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 09-12-7

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3766

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3766 2-drill holes thru to finish size as per dwg D3766 using DT9413, Drill holes labelled #3. 3- deburr

7 m. k 094

20X
10/01/05

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8 10/01/05

counter
20

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BK 10-01-5

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54303

December 7, 2009 3:08:15 PM



Page 2

Item ID: D3766-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Rail

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00



M 10-06-01

QC

Memo

0.00

Quality Control

(120)

Ø

140

Identify as per dwg & Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

10/01/06

(20)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

mf 10-01-06

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NOTE: Date & initial all entries

Picklist Print

December 7, 2009 3:08:19 PM

Page 1

Work Order ID: 54303

Parent Item: D3766-3

Parent Item Name: Rear Rail


Comments:

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	56.1948	58.7937			
												
6061T6 RD TUBE 1.00 X .188W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	56.1947542	
109041	1.03	
112529 ✓	53.5647542	
18101	1.6	

M113511

M-L 10/01/05

11X

9X

*

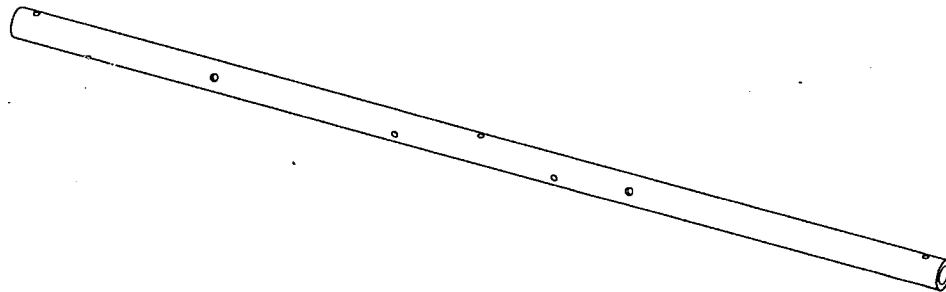
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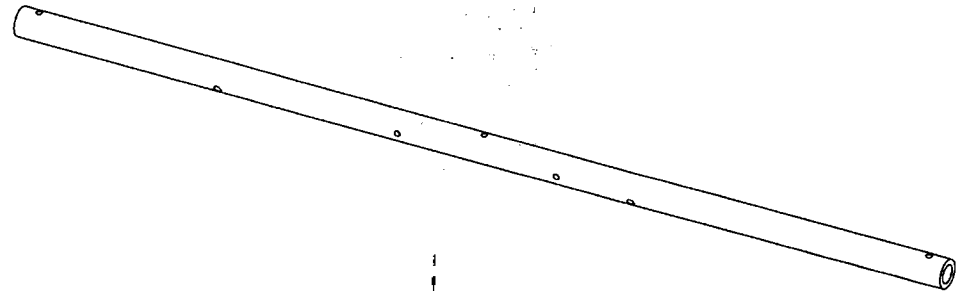
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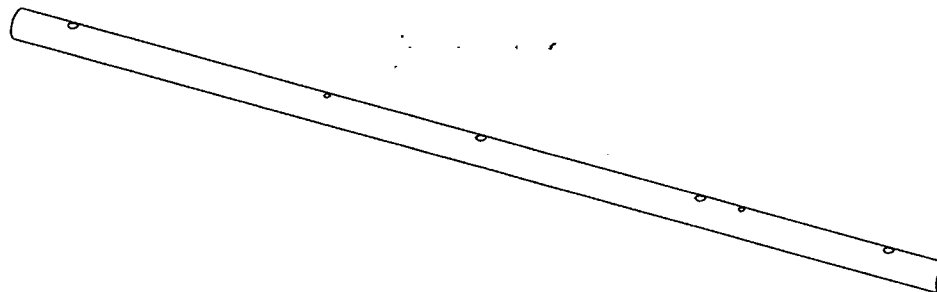
NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH



D3766-2 FRONT RAIL, RH



D3766-3 REAR RAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 541363
08-12-07

RELEASED
08.07.10

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	RAIL	NTS
DATE	08.06.10	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

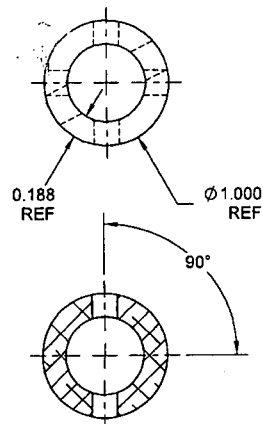
W/O:		WORK ORDER CHANGES					
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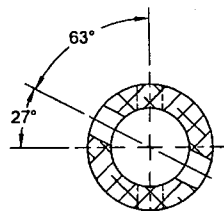
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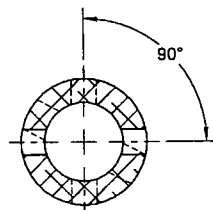
NOTE: Date & initial all entries



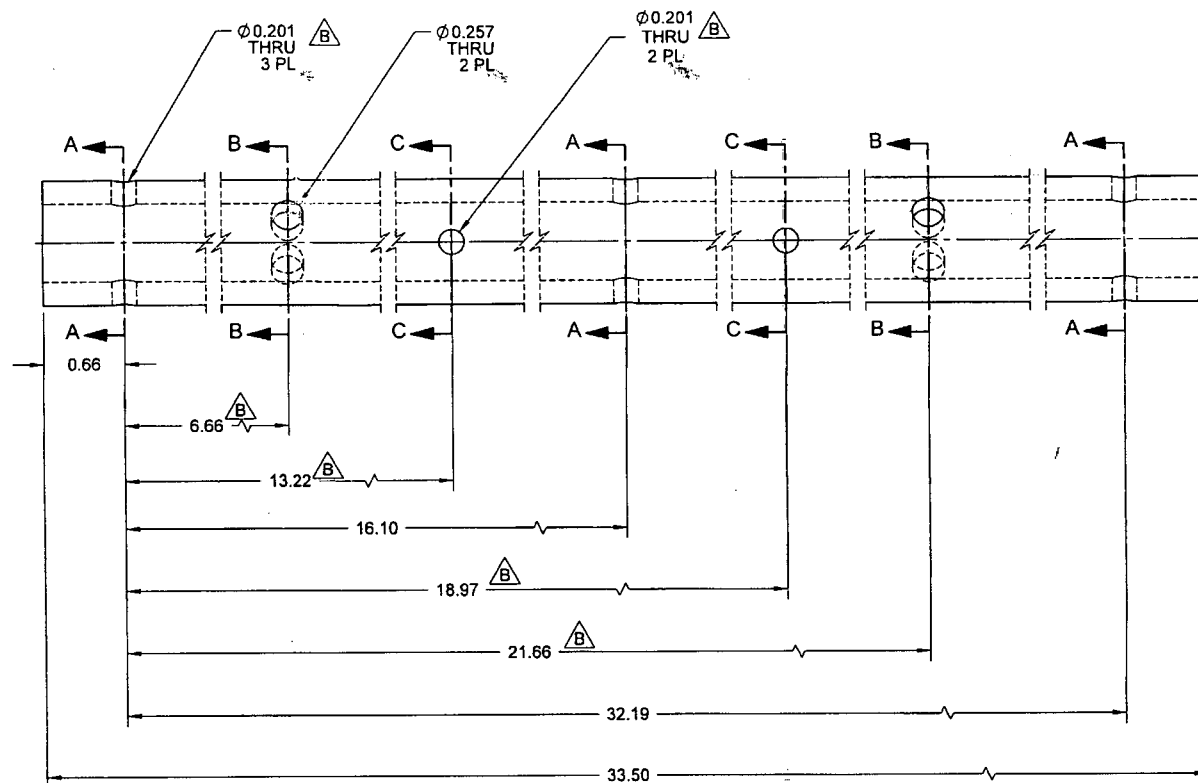
SECTION A-A



SECTION B-B



SECTION C-C



D3766-1 FRONT RAIL, LH

RELEASED
08-07-10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 2 OF 4
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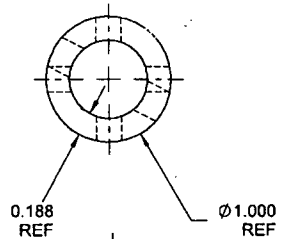
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

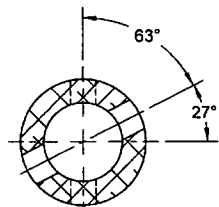
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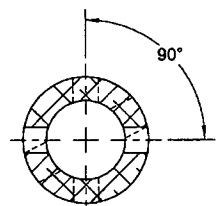
NOTE: Date & initial all entries



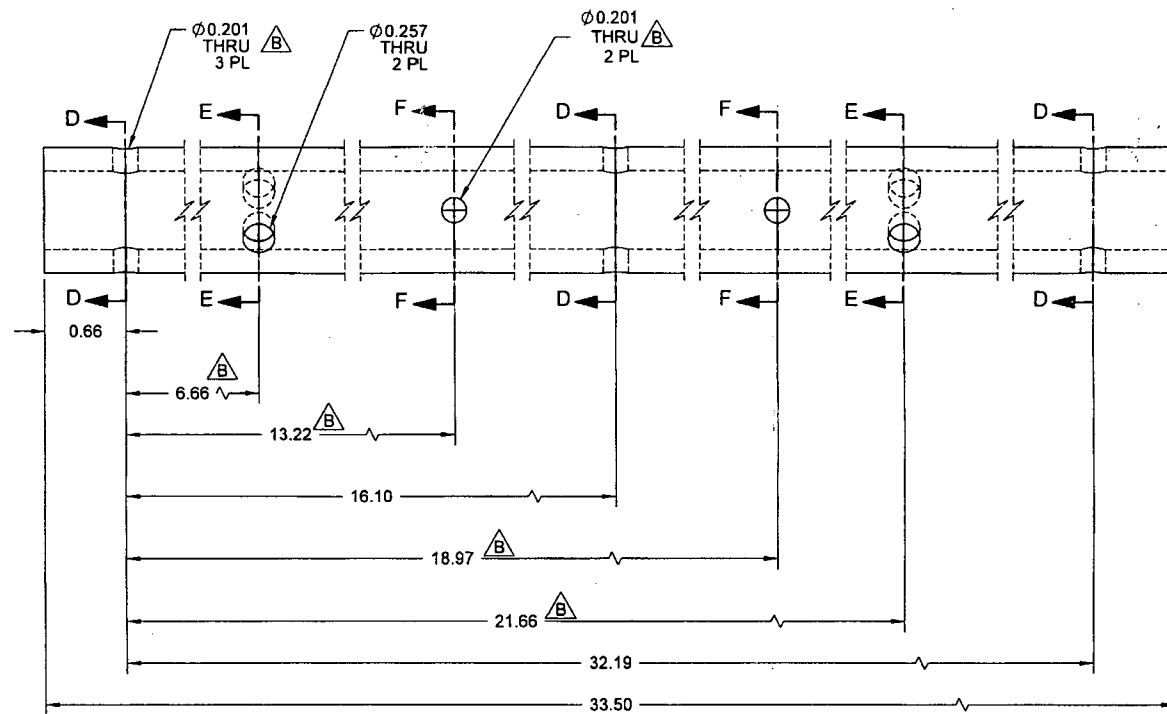
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

RELEASED
08-07-10 MP

W/054303

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W/O:		WORK ORDER CHANGES					
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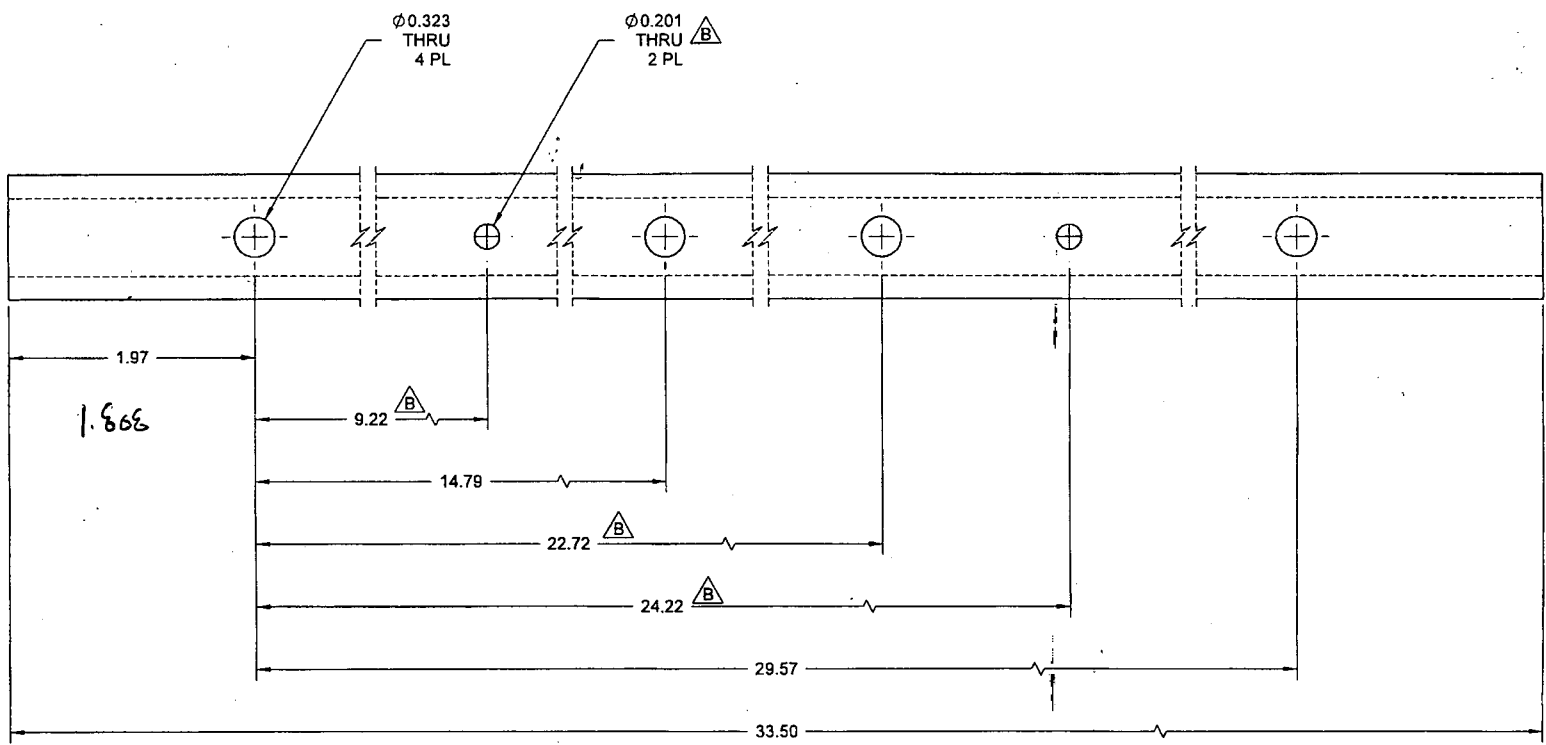
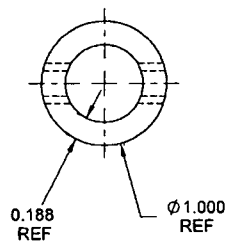
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D
C
B
A

D3766-3 REAR RAIL

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3766	SHEET 4 OF 4
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W/1054303

10-05-10/11P

8 7 6 5 4 3 2 1

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